

Date: Monday, 29/09/2008 11:36:12 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 350 SKIDTUBE ASSEMBLY LH

Job Number : 42335

Estimate Number : 10262

P.O. Number :

This Issue : 29/09/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 11 Type : SKIDTUBES

Previous Run : 42157

Part Number : D350636011

Drawing Number : D2750 REV F

Project Number : N/A

Drawing Revision : F

Material :

Due Date : 08/10/2008 Qty: 1 Um: Each

Written By :

Checked & Approved By : JLD 08.9.29

Comment : Est Rev: I 02-09-25 Rearranged procedure steps KJ

Est Rev: J 06-03-23 As per Rev D JLM

Est Rev: K 06-07-13 As per dsi9343 EC

Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM

Verified By: EC

Est Rev: M 08-04-22 update steps 4, 13 DD verified by: EC

Est Rev: N 08-09-23 rev F as per dwg DD verified by: ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.10.08



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B 42342 ① H 8-10-2

3.0 D2744 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B 39242 ① H 8-10-2

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2- Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 & DT8863.

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:

Machine Or Operation:

Description:

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750. *u 8-10-2*

4-Drill pilot holes for Detail G using DT8330

5-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 5 holes per side) as per dwg D2750. Open up holes for ground handling and detail E to 0.500" (8 holes per side) *u 8-10-2*

6-Drill pilot holes for wearplates as per Dwg D2750 using DT8108

****Make sure that wearplate holes are on bottom of tube***** Open 4 aft wearplate holes to 0.250". Open remaining wearplate holes to 0.297"

7-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004
A/R Aluminum Rod *m/09213 H 08/10/02*

10-Grind welds flush as per Dwg D2750 *} RT 08-10-02*

12- Scribe batch# inside per dwg D2750

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *8 08/10/03 (X1)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *8 08/10/03 (X1)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *Jb 8-10-3*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION *u 8-10-6*

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Job Number: 42335

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	D2739	350 I Beam
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B42419

JD 8-10-6

10.0	D34901	Cross Bolt Spacer
------	--------	-------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 842185

RE 08-10-07

11.0	D34903	Cross Bolt Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: 842186

RE 08-10-07

12.0	D2743	Crossbolt Spacer
------	-------	------------------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: 8387855

RE 08-10-07

13.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail E and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, E, ground handling and float holes per dwg D2750 (welding instructions on
sheet 4)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

JD 8-10-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42335

Part Number: D350636011

Job Number:



Seq. #: Machine Or Operation: Description :

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: ~~4-11-01~~ 109038

exp. date: 8-11-01

Job 8-10-6

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 4)

A/R Aluminum Rod

batch: M 109213

BE 08-10-07

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section P-P (total of 4 places per side) as per dwg D2750

11-Debur holes

2T 08-10-07

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/08 (X)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08 (X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-h

08/10/09

(14)

17.0

POWDER COATING

POWDER COATING



M 109152



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50
320 OF
8:20

M-h

08/10/11

(12)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

08-10-14

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42335

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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19.0	ALS41032225	Insert
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Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Insert

Batch: M100621 *HL*

20.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Install inserts as per Dwg D2750

HL

08-10-14 (x1)

21.0	D2745	Bushing
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B41114 *HL*

22.0	D37911	Wearplate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B42418 *HL*

23.0	D37931	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B410551 *HL*

24.0	D37933	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearshoe

Batch: B342247 *HL*

25.0	D37941	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B40553 *HL*

08-10-14 (x1)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 42335

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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26.0

D37943

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B34713

JS

27.0

D353525

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B41633

JS

28.0

D353625

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B42234

JS

29.0

D35371

Wearpad



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B41082

JS

30.0

D36311

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: B41741

JS

31.0

D3488041

Blade Fitting Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B338786

JS

32.0

D3492041

Plug Assembly



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B42182

JS 08/10/16 *0*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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33.0	D3492043	Plug Assembly
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: 1341138

Handwritten signature

34.0	AN3C5A	Bolt
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Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M1108928

Handwritten signature

35.0	AN3C6A	BOLT
------	--------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M1108880

Handwritten signature

36.0	AN6C44A	BOLT
------	---------	------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M1109091

Handwritten signature

37.0	AN8C35A	BOLT
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M1106896

Handwritten signature

38.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M1109431

Handwritten signature

39.0	AN960C816L	WASHER
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M1108928

Handwritten signature

08-10-14

Handwritten circled number 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 42335

Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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40.0	MS210436	NUT
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M109249

JH

41.0	MS21083C8	NUT
------	-----------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M109485

JH

42.0	NAS1515H3L	WASHER
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

WASHER

Batch: M108964

JH

43.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3" batch: M107912

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

✓ SIKA FLEX 241

BATCH: M109338

EXP DATE: 08/11

✓ 4-Coat all exposed fasteners with "LPS Procyon" batch: *JH* 08.10.16

44.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/16 *(XU)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636011

Job Number:



Seq. #:	Machine Or Operation:	Description :
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45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

46.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Blade
Batch: 40724

50

47.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M109092

50

48.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
Batch: M108928

50

49.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: M107581

M108964

50

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M109545

50

51.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
WASHER
Batch: 40829

8/10/17

50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Part Number: D350636011

Job Number:



Seq. #:

Machine Or Operation:

Description :

52.0

D35321

Spacer



12

Comment: Qty.: 2.0000 (s)/Unit Total: 2.0000 (s)
batch: 2411346

8/10/19

50

53.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/10/20 (20)

54.0

PACKAGING 1

PACKAGING RESOURCE #1



(12)

Comment: PACKAGING RESOURCE #1
Package as per PPP D350-636-011

G

8/10/20

3

55.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-22

342335

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

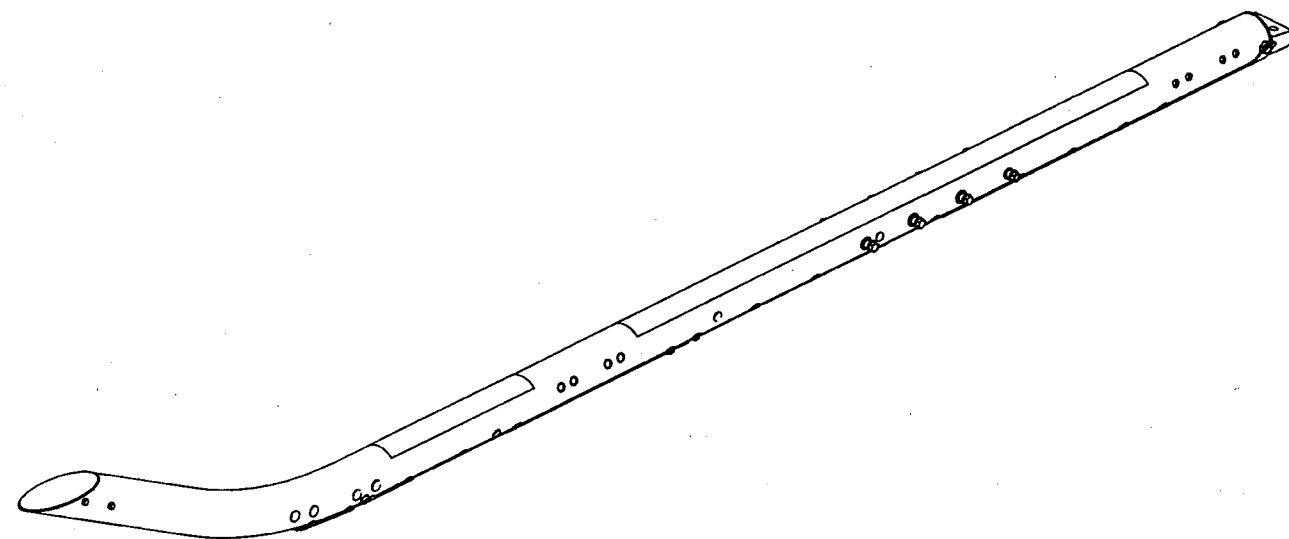
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

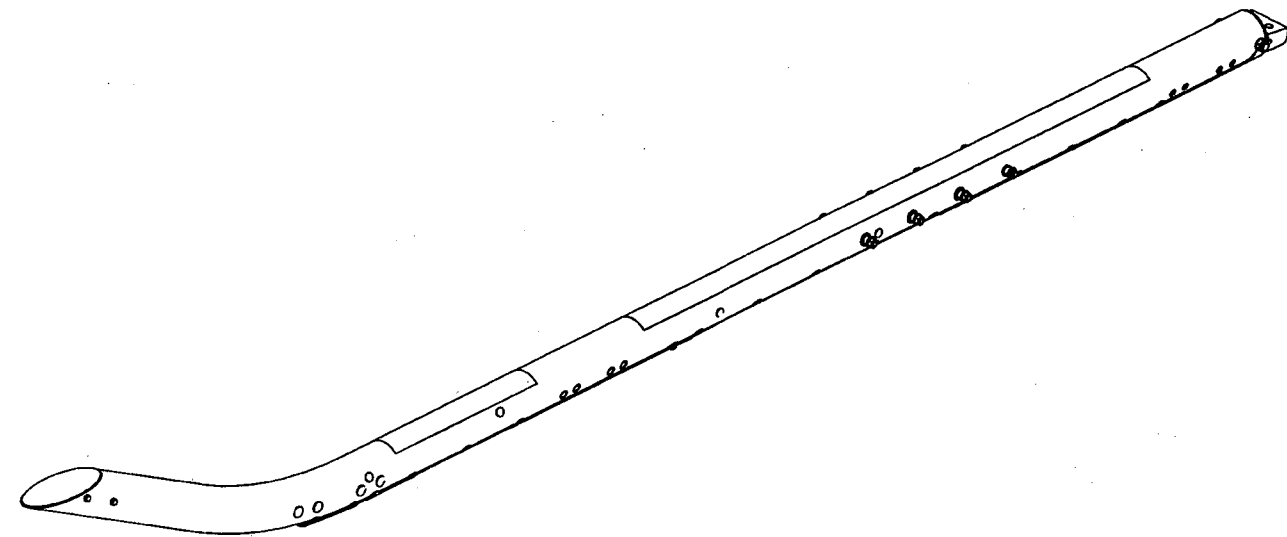
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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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MFG. APPR.	AK	D2750	SHEET 1 OF 11
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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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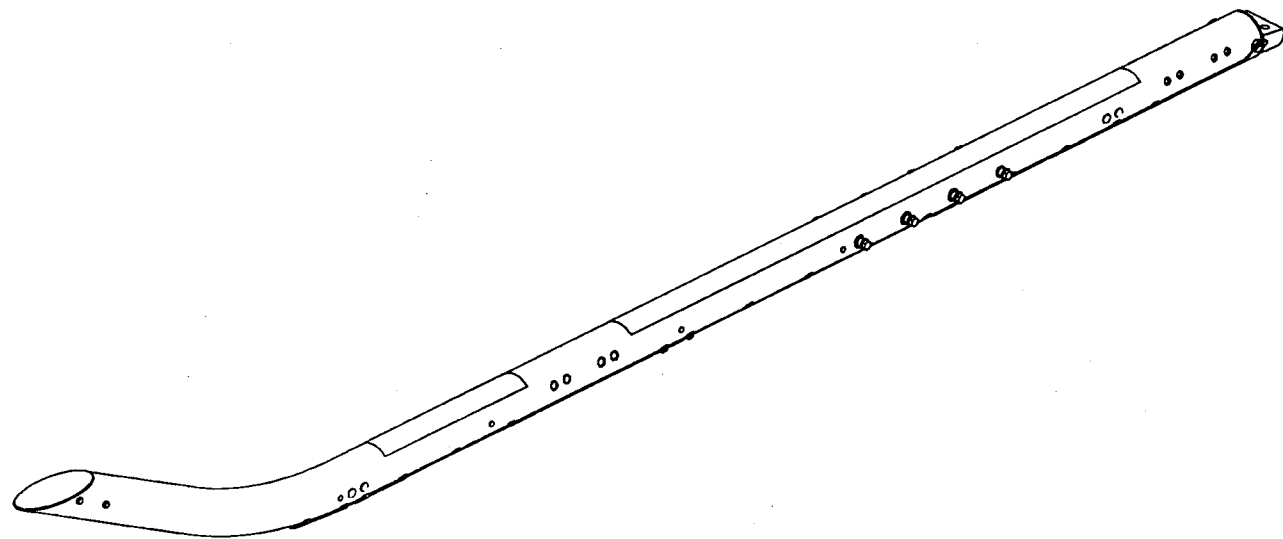
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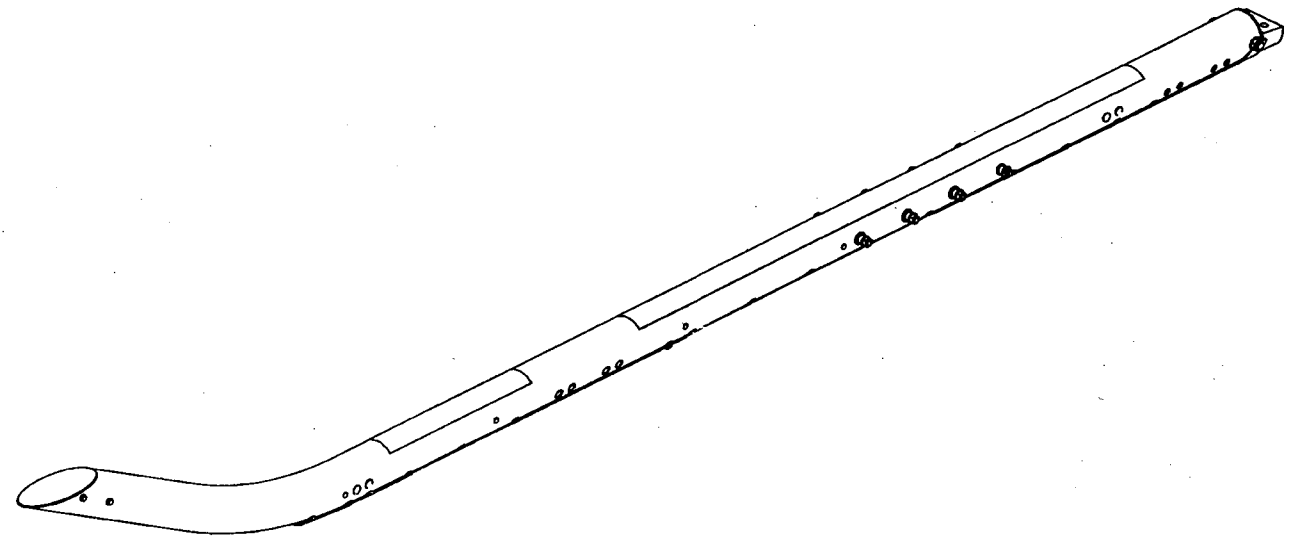
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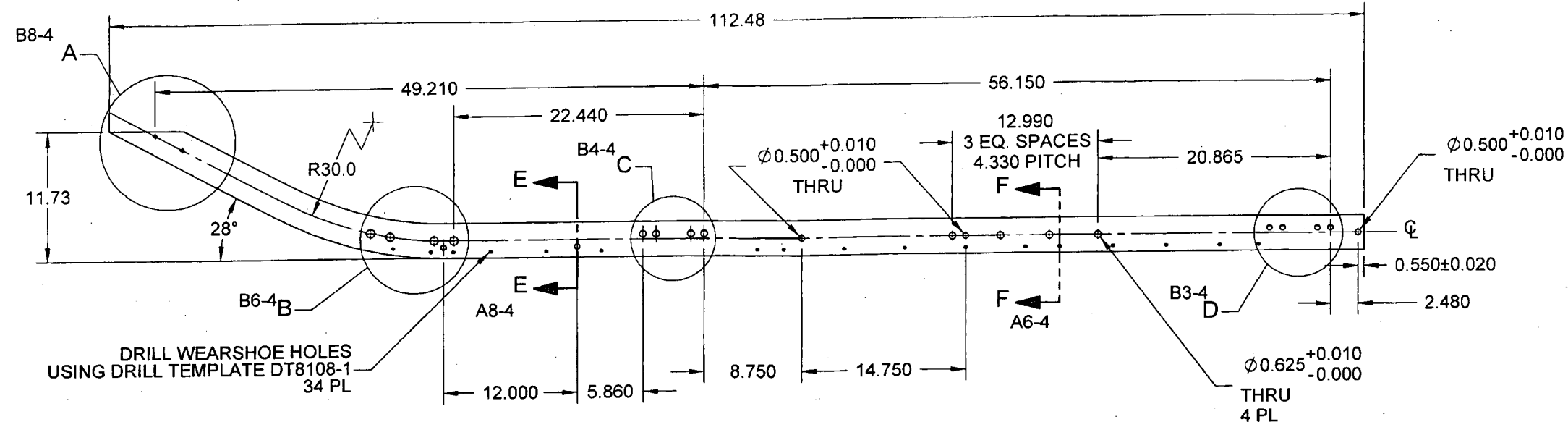


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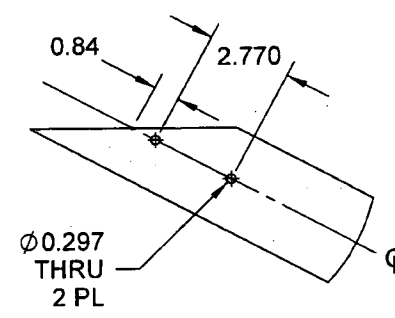
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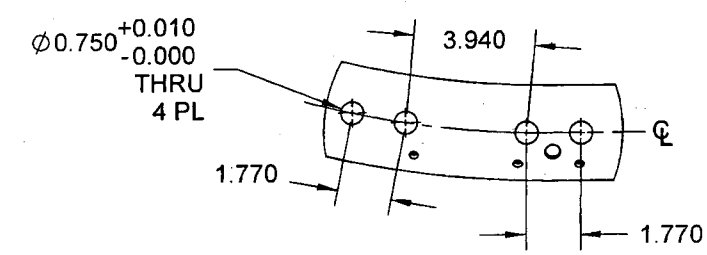
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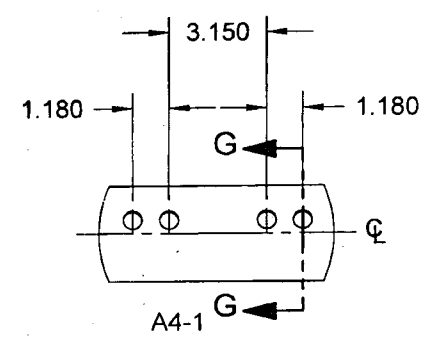
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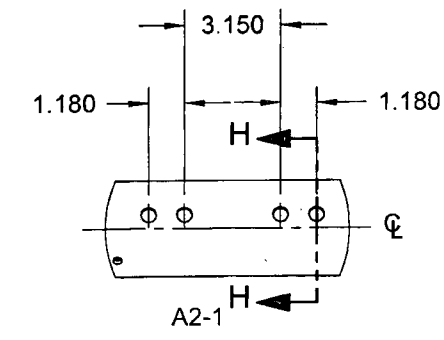
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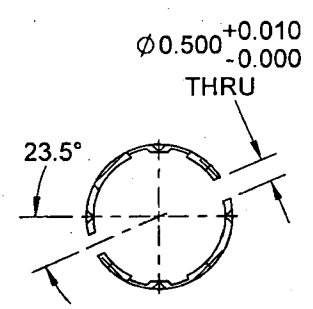
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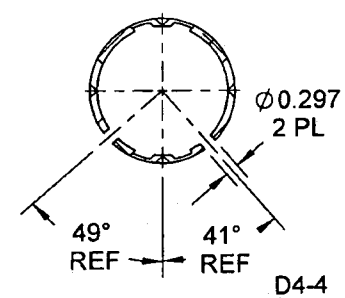
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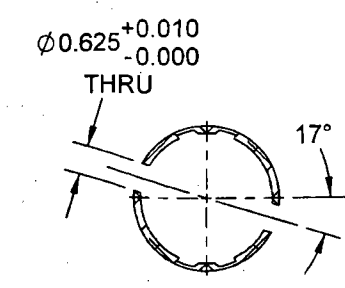
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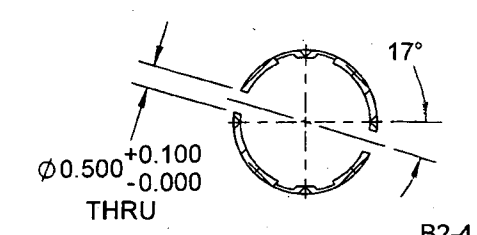
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



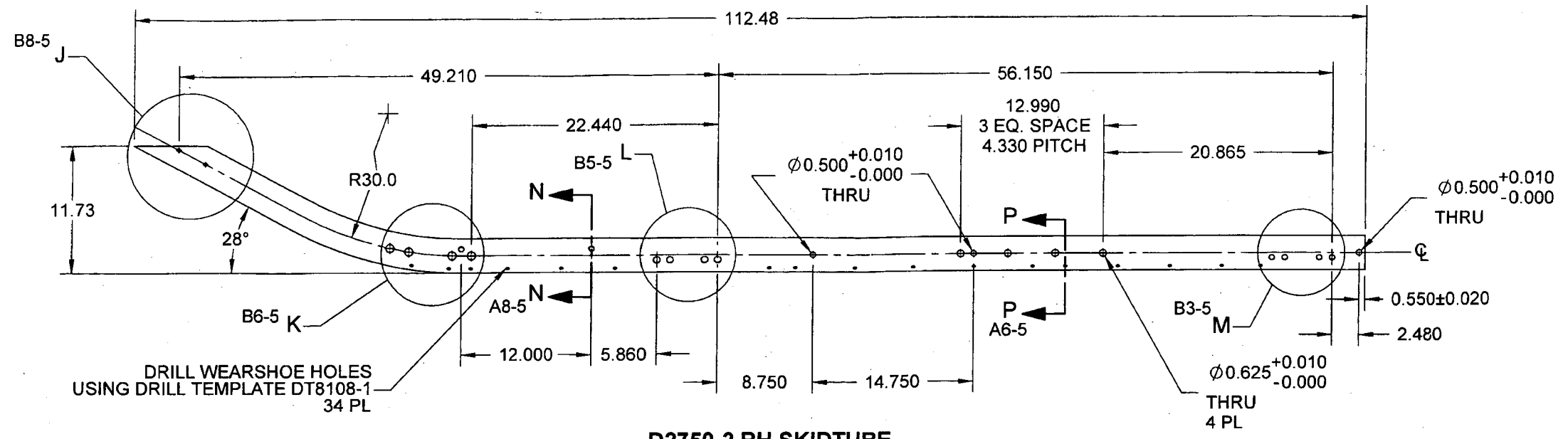
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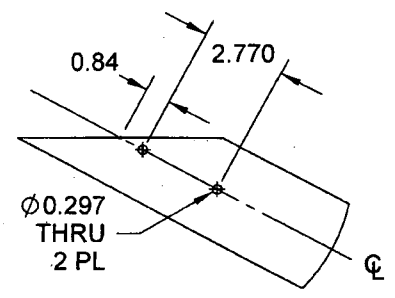
SECTION H-H
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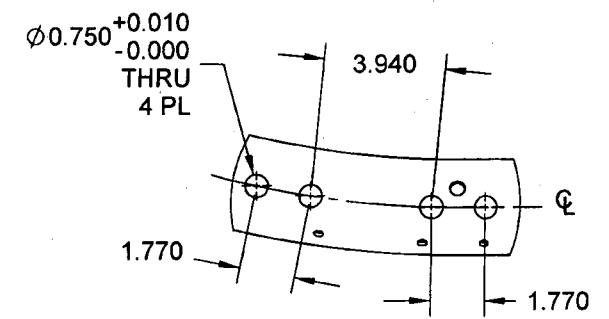
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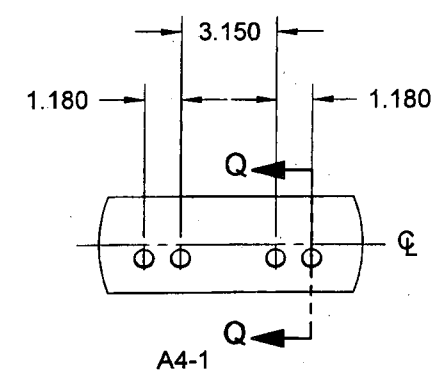
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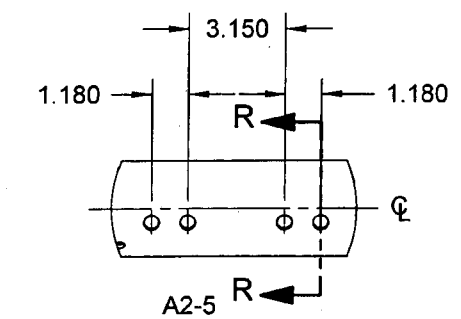
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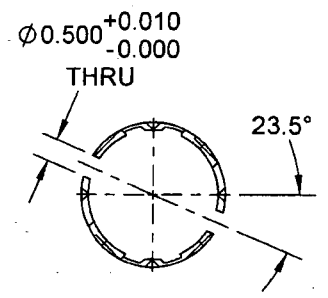
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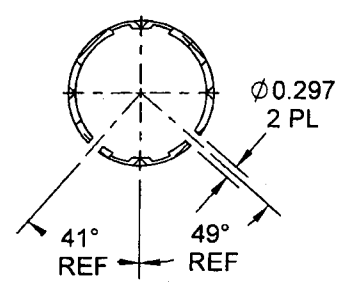
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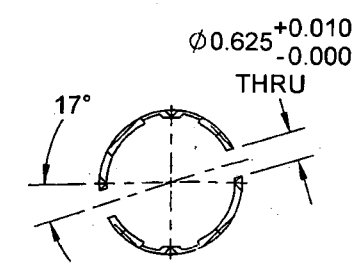
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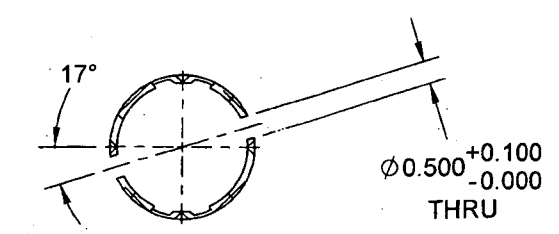
SECTION N-N
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SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



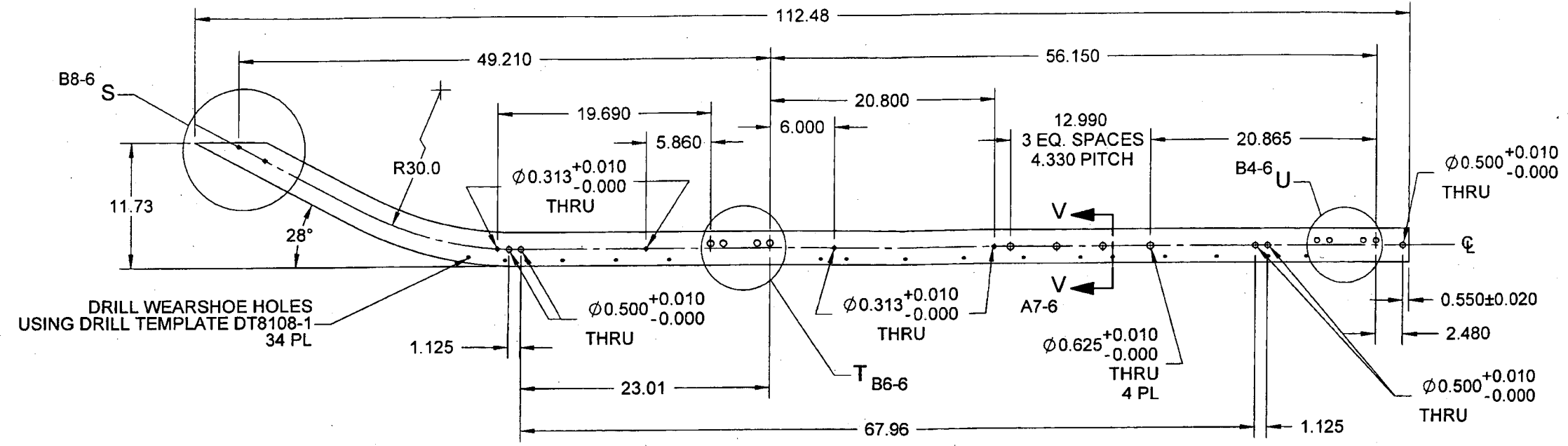
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SCALE 3X, 4 PL

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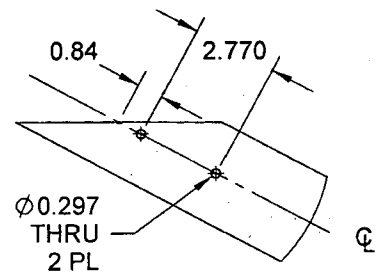
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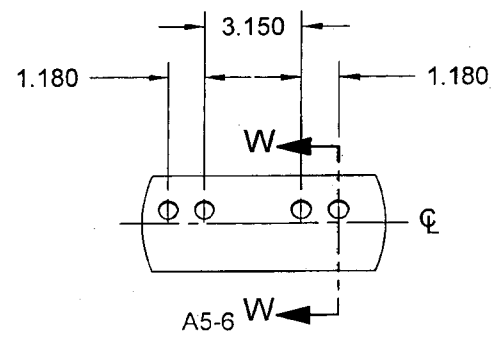
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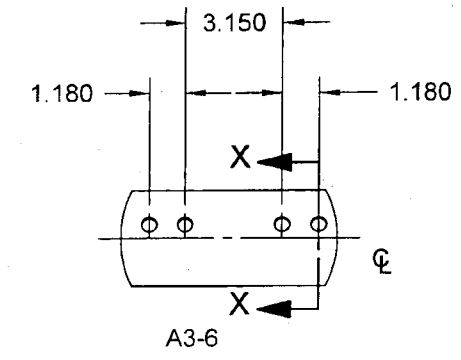
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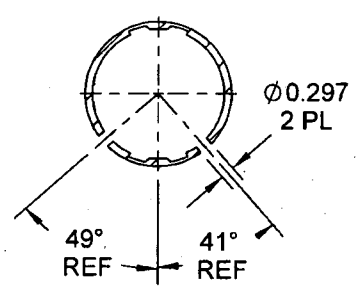
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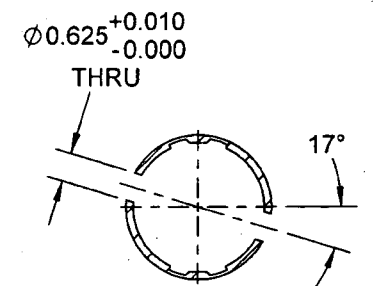
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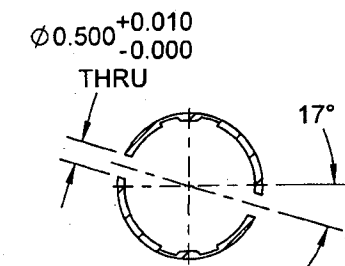
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SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL

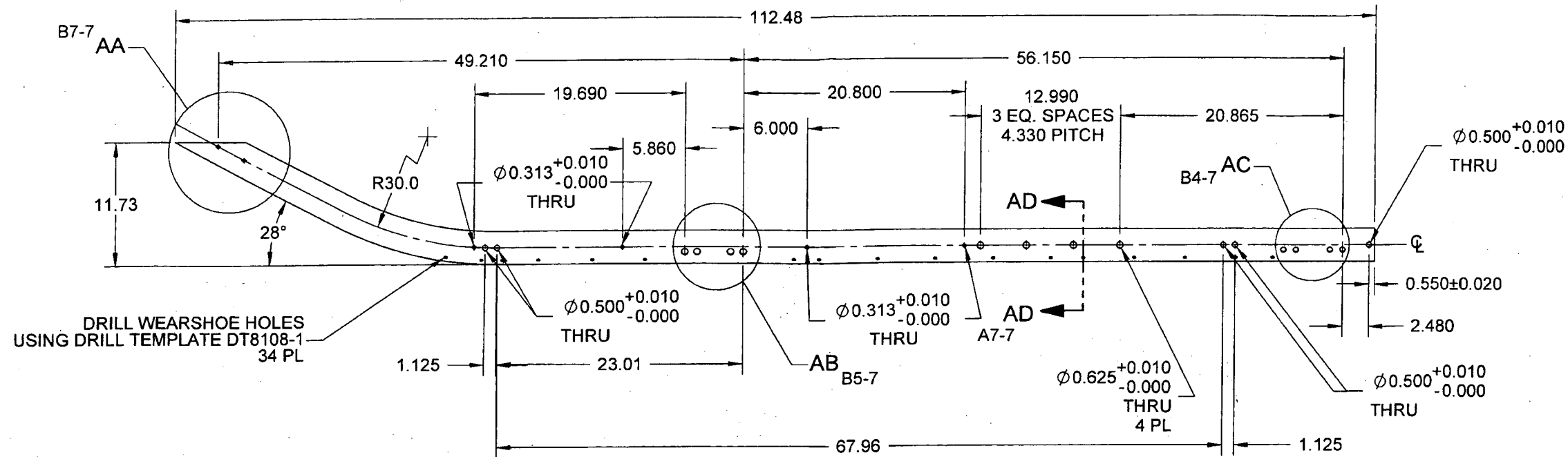


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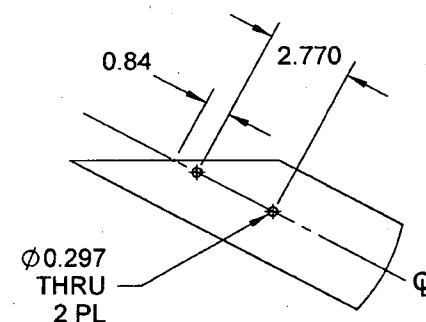
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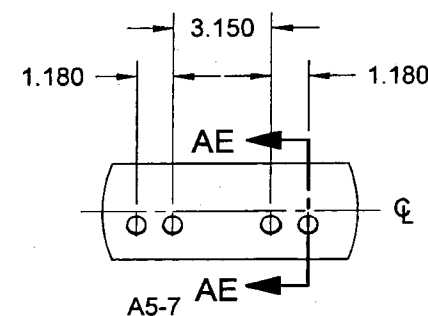
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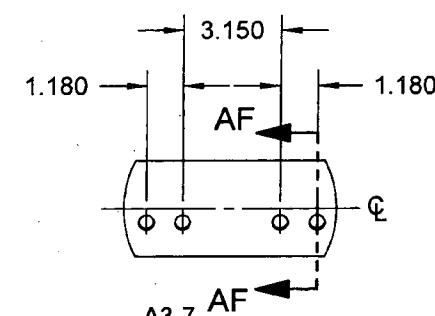
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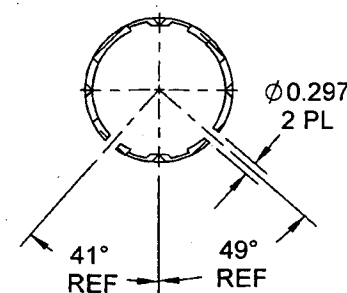
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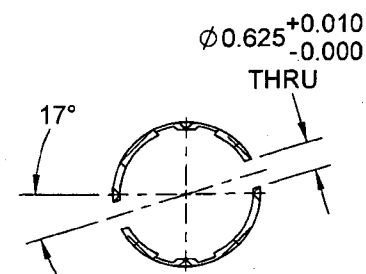
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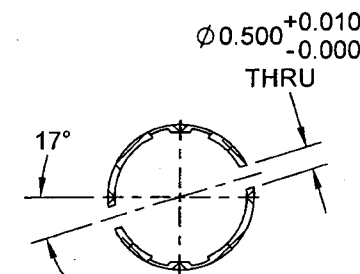
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SECTION AD-AD
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SECTION AE-AE
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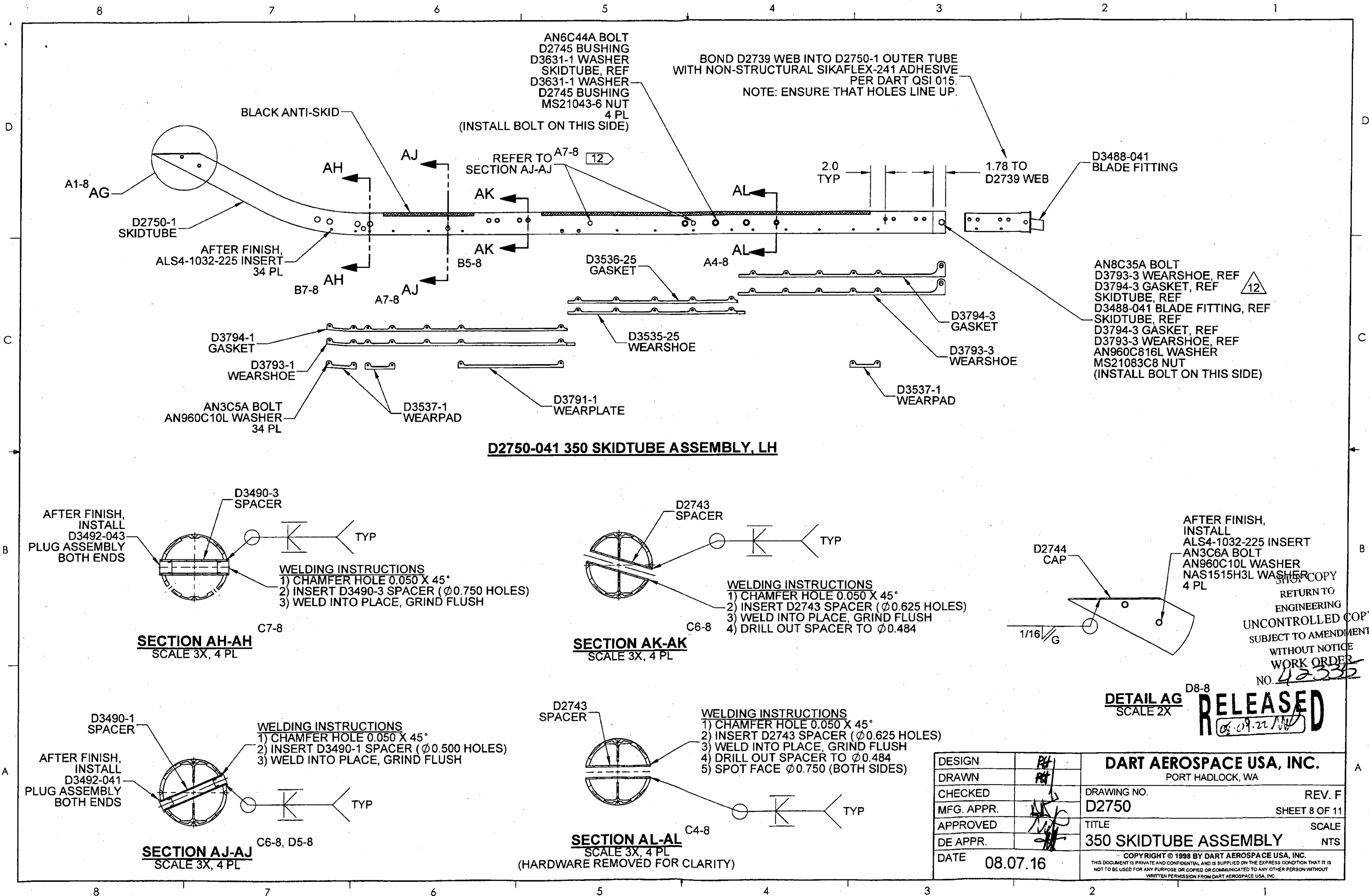


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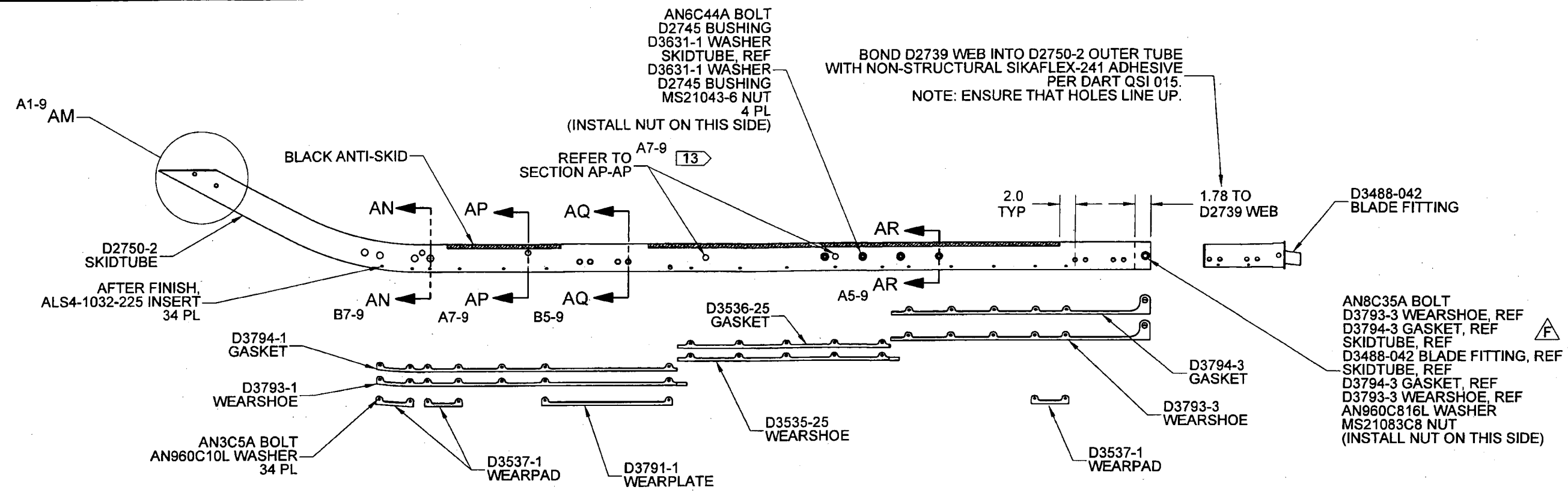
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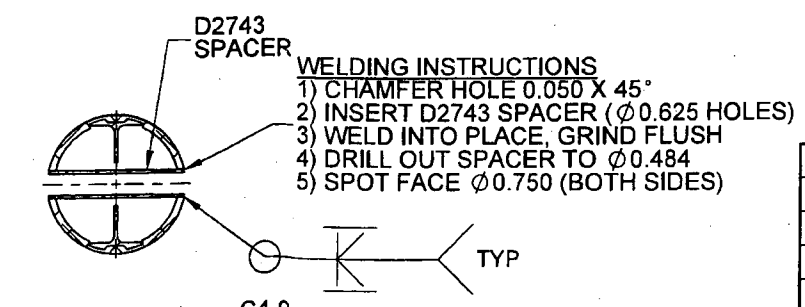
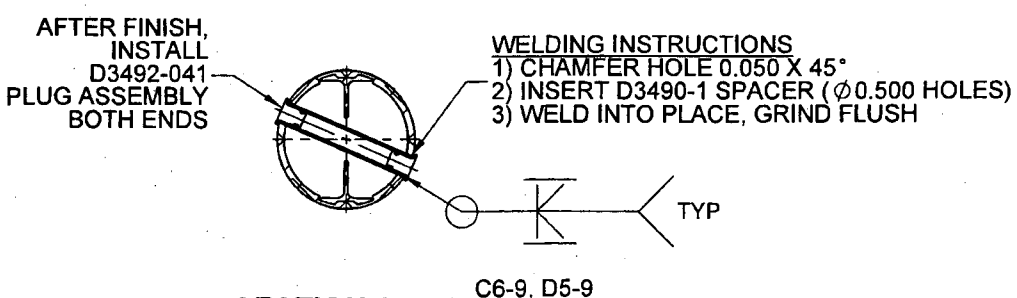
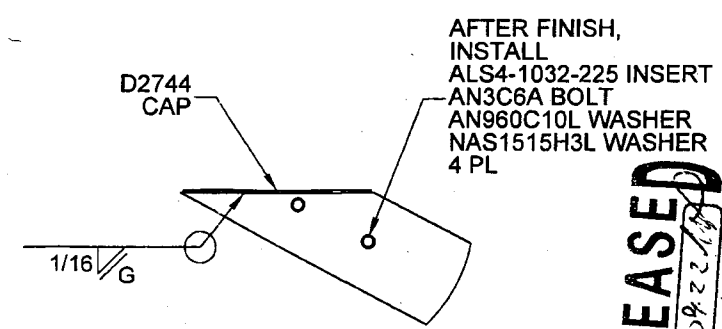
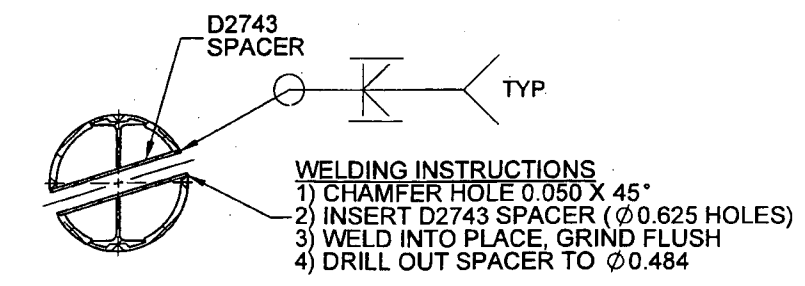
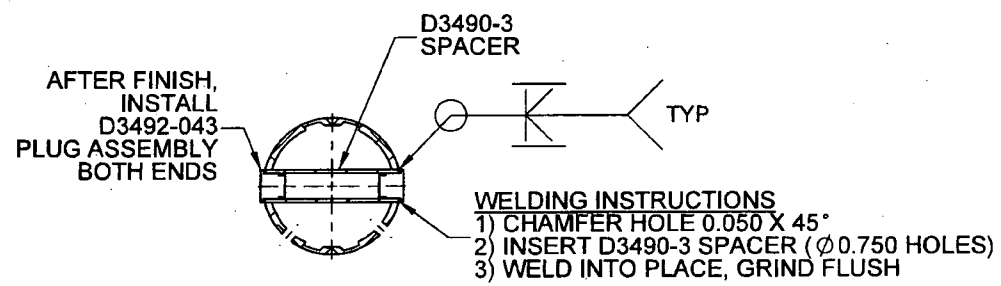
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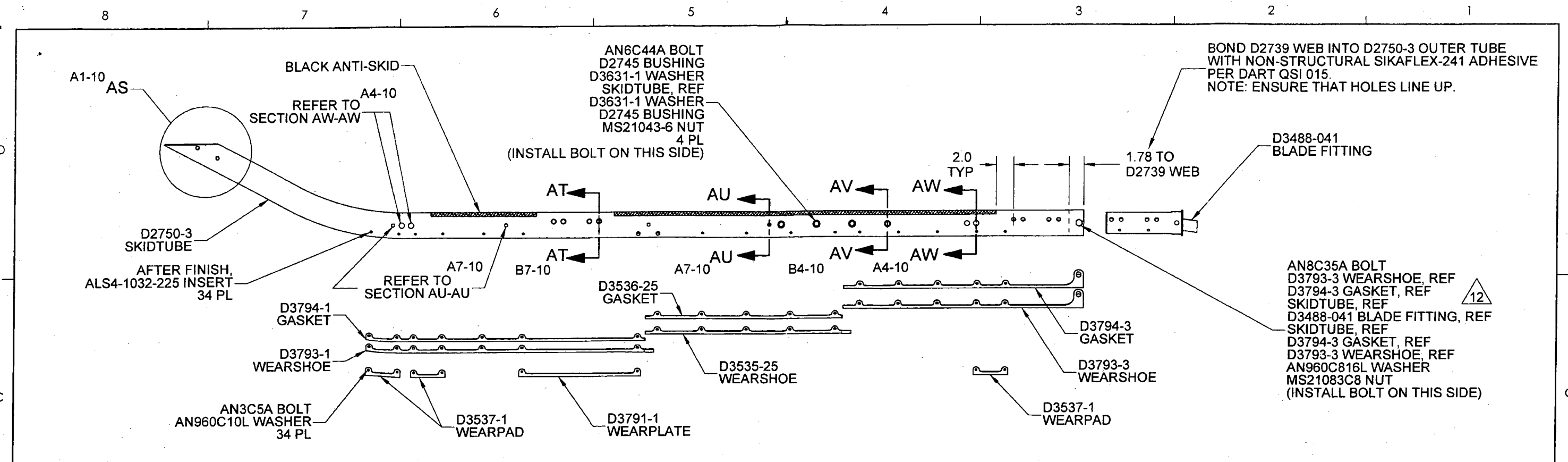
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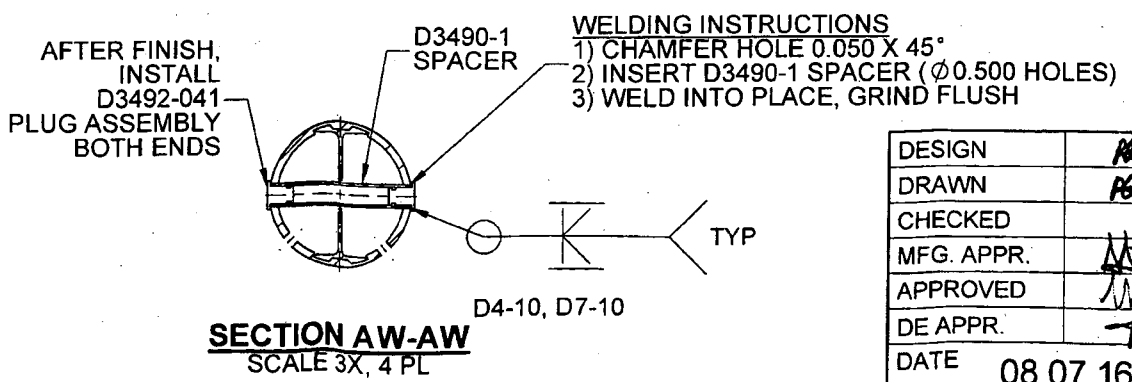
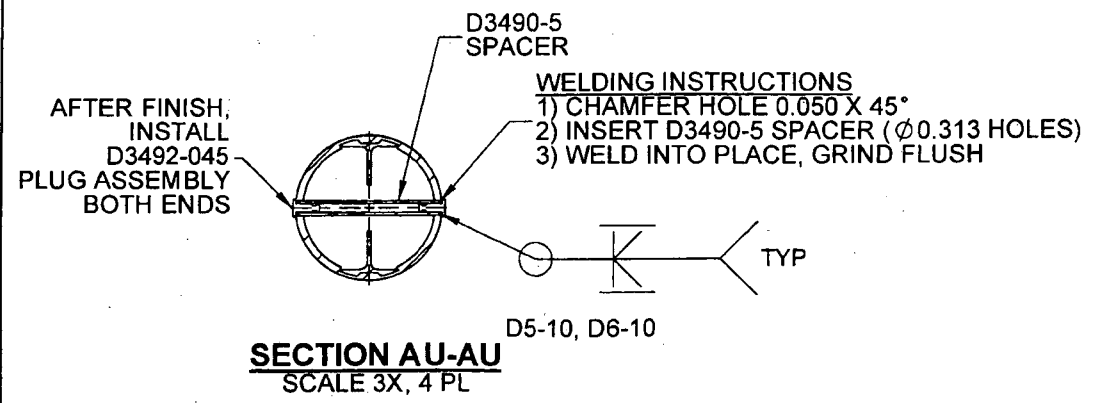
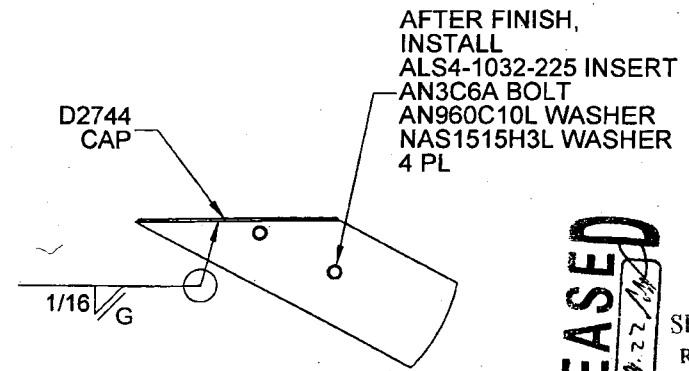
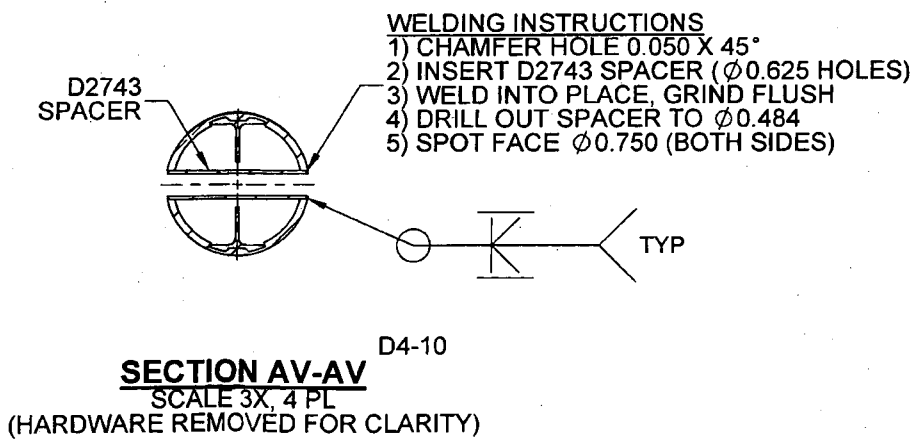
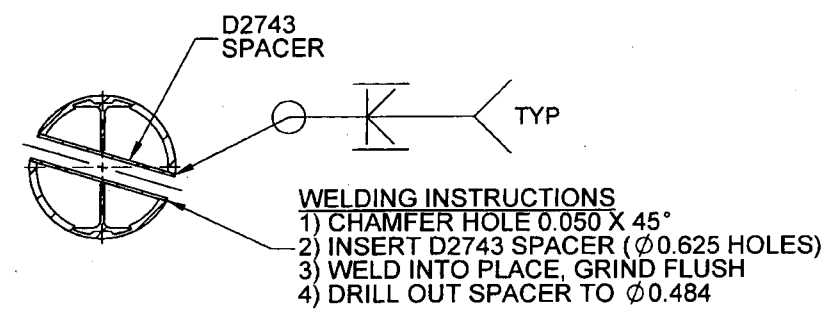
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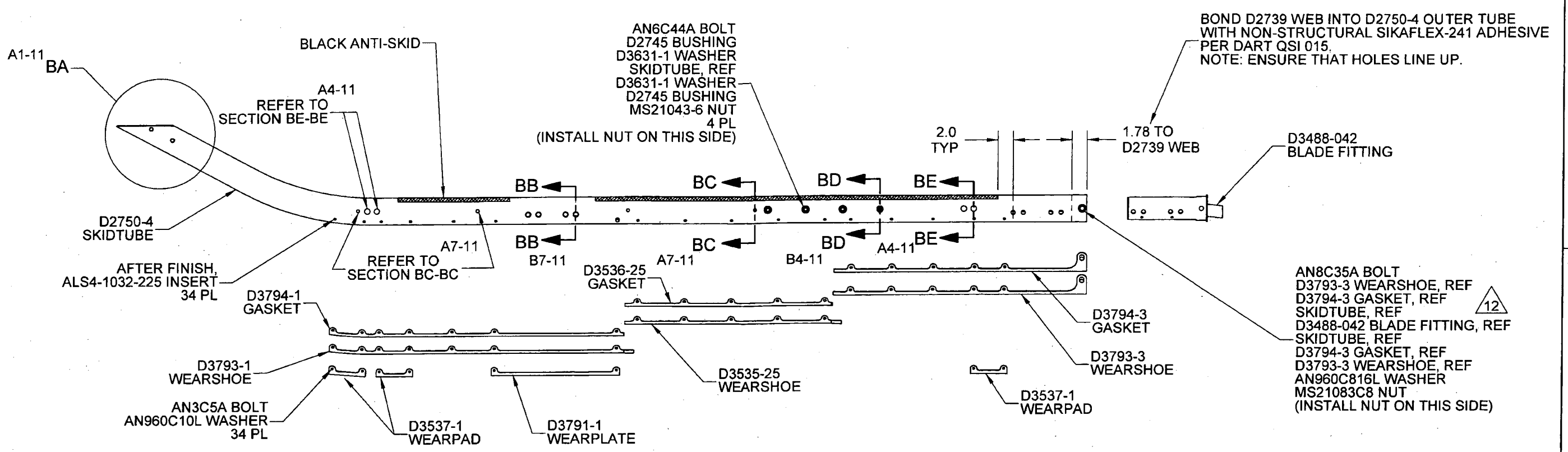


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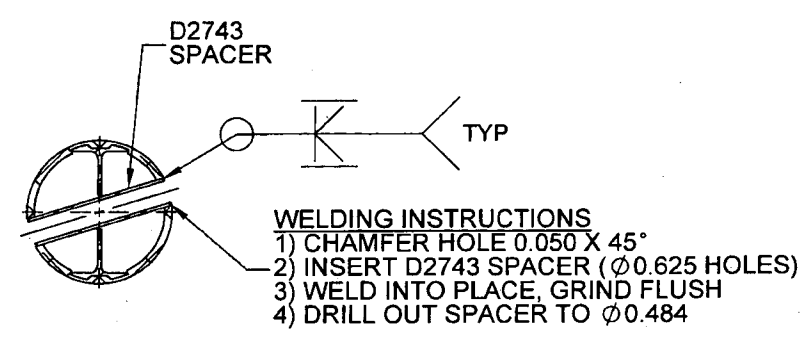


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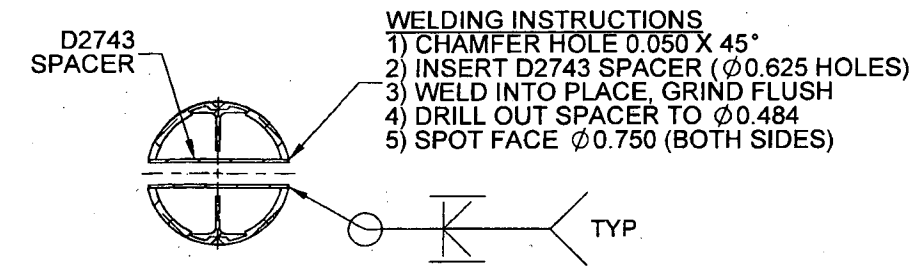
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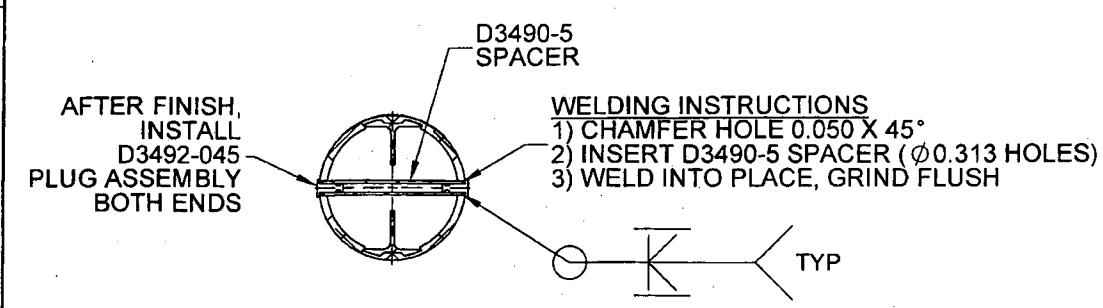
D2750-044 350 SKIDTUBE ASSEMBLY, RH



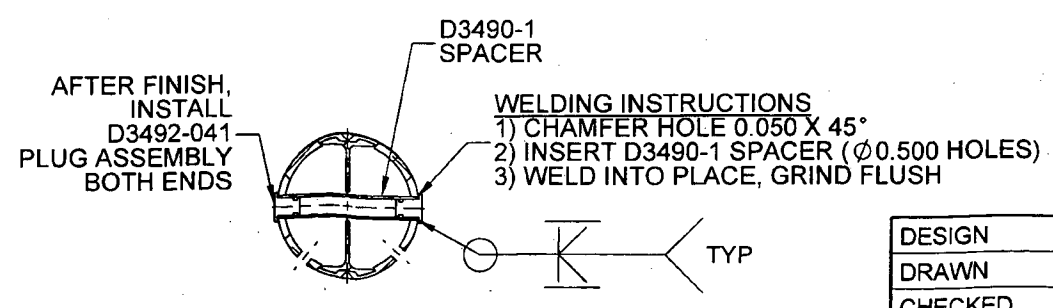
SECTION BB-BB
SCALE 3X, 4 PL



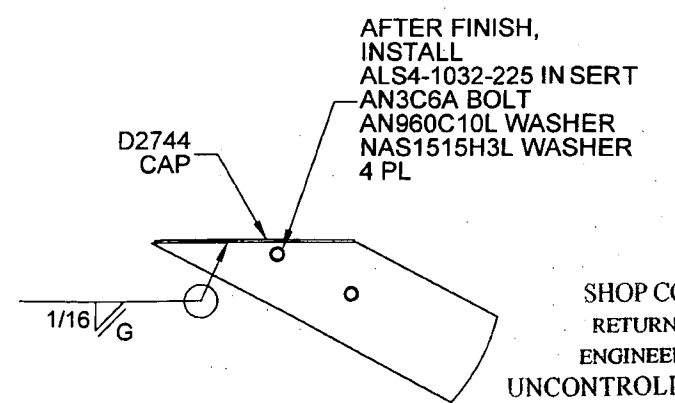
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

RELEASED
08-07-22

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DE APPR.	MB	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NO. 175

(352)

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41860
Part number: D350 636011
Description: 350 skid
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Dineen Date of Test Coupon 08-09-26
Welder Barclay Elliott Date of Test Coupon 08-09-26

The above named individual is qualified in accordance with AWS D17.1.2001 to weld